

ST115/ST121F



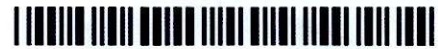
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Gloss Black

D4776-3

Job Sheet 203518



Part No: D4776-3

Job Qty: 4 pcs

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/19

Job Tracking No: Gloss Black

Due Date: 12/5/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D4776 REV.E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER
REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
165	Rework Startup	4 pcs	12/5/19	0.00	0.00		Powdercoat - 1		
							Powdercoat - 2		BE819-11-29
							Powdercoat - 3		
							Powdercoat - 4		BL 19-12-6
170	QC 3	4 pcs	12/5/19	0.00	0.00		QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		
							QC 3 - 19		
							QC 3 - 43		
							QC 3 - 24		
							QC 3 - 61		
							QC 3 - 81		
180	Packaging 3-1 - Stock - B4B	4 pcs	12/5/19	0.00	0.00		Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

Plex 11/20/19 3:02 PM dart.lacelle.linda

DAS
81
9-89

DEC 11 2019

DAS
74
9-89

610Z 12 DEC 2019 15

Packaging 3 - 4 - B4B	
Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	

190 QC 21 - SA 4 pcs 12/5/19 0.00 0.00

glass black

QC 21 - SA - 21
QC 21 - SA - 70
QC 21 - SA - 53
DEC 12 2019

Part Op 165 - Scuff and re powder coat Powder coat white gloss as per QSI005 4.3.5 START TIME: _____ OVEN
Descriptions: TEMPERATURE: _____ FINISH TIME: _____
170 - (QC3- Inspect Part Finish)
180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

m. 4.013202

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4776-3	Skidtube Clevis	4 pcs (1 ea)	165-Rework Startup	<i>5.214182</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
165-Rework Startup	D4776-3	4	40	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.430inches $\pm$ 0.030	4.460 4.400		
2	Skidtube Clevis	2.300inches $\pm$ 0.030	2.330 2.270		
3	Skidtube Clevis	1.778inches $\pm$ 0.010	1.788 1.768		
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		
5	Skidtube Clevis	0.510Inches $\pm$ 0.010 + 0.010 - 0.000	0.520 0.510		
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053		
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350		
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		
9	Skidtube Clevis	0.100inches $\pm$ 0.010	0.110 0.090		
10	Skidtube Clevis	0.484Inches $\pm$ 0.006 + 0.006 - 0.001	0.490 0.483	Diameter	
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		
12	Skidtube Clevis	0.640inches $\pm$ 0.030	0.670 0.610		
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140		
14	Skidtube Clevis	1.080inches $\pm$ 0.010	1.090 1.070		
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678		
16	Skidtube Clevis	0.397Inches $\pm$ 0.006 + 0.006 - 0.001	0.403 0.396	Diameter	
17	Skidtube Clevis	1.863inches $\pm$ 0.010	1.873 1.853		
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius	
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius	
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115		
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	
25	Skidtube Clevis	1.050inches $\pm$ 0.030	1.080 1.020	Product	
26	Skidtube Clevis	1.430 $\pm$ 0.030			
27	Skidtube Clevis	1.130inches $\pm$ 0.030	1.160 1.100	Product	
28	Skidtube Clevis	0.060 $\pm$ 0.030		Product	
29	Skidtube Clevis	0.810inches $\pm$ 0.030	0.840 0.780	Product	
30	Skidtube Clevis	0.060 $\pm$ 0.030		Product	
31	Skidtube Clevis	0.183inches $\pm$ 0.010	0.193 0.173	Product	



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Container No: S236172



Part: D4776-3

Job No: 203518

Serial No/Batch: S236172

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/19